

Aero Design Ltd.**Work Order Control Sheet**Work Order#: 2015-81 Date Opened: 15-Jul-15 Title: FabricationAircraft OEM: Bell Aircraft Model: 206L/407 Product Type: Lids Product Model: Standard Quantity: 20**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification
Time Sheet (R&D)
Notes

Initial or N/A

JR
N/A
JR
JR
N/A
N/A
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JR
JR

Drawing List

Drawing #	Rev #	Description	Initial or N/A
69812	4	Lid	JR

Traveller

Initial or N/A

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

6
N/A
N/A
JR

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Tracking (White) Tags Completed
Parts Placed in Stores for Distribution

Initial or N/A

N/A
N/A
N/A
N/A
JR
N/A

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

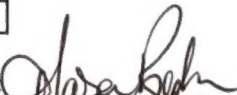
Initial or N/A

JR
N/A
N/A

Work performed by:

Print: J Rekve for M Rekve

Sign:



SCA: AD01

Date: 28-Jul-15

ICC / Dual Inspection preformed by:

Print: Jason Rekve

Sign:



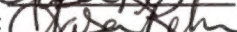
SCA: AD01

Date: 28-Jul-15

Work Order closed by:

Print: Jason Rekve

Sign:



SCA: AD01

Date: 28-Jul-15

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014

CARGO BASKET LID FABRICATION - COMMON

General

These instructions apply to all cargo basket lid assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69812, Revision 3 – Standard Low Mounted Basket; Extra-Wide Low Mounted Basket

94612, Revision 0 – Extra-Wide Low Mounted Ski Basket

76612, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right

77612, Revision 1 – Short Basket

69812, Revision 3 – Medium Basket (left and right)

78412, Revision 2 – Long Basket

94012, Revision 0 – Extra Large (ski) Basket

Robinson R44 – left or right

90612, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80212, Revision 0 – Short Basket

80312, Revision 0 – Medium Basket

81112, Revision 0 – Long Basket

Bell 429 – right or left

95912, Revision 0 – Standard Basket

Bell Medium – left or right

75112, Revision 0 – Standard Basket

95512, Revision 0 – Extra Large (ski) Basket

MD600

82812, Revision 0 – Standard Basket

Options

70405, Revision 3 – Walkway

70402, Revision 1 – Lid Door

CARGO BASKET LID FABRICATION

Complete
(initial or SCA #)

Work Order: 2015-81

Date Open: 15 Jul 15

1. Rim Assembly – Basket Lid

- a. Cut and fit $\frac{3}{4}$ " x 0.035 material to fit rim jig, 45 degree ends.
 - i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
- b. Record material PO on attached material list.
- c. Remove writing on tubes with acetone and scotch bright.

AD06 NO

2. Weld Rim Assembly

- a. Record welding rod PO on attached material list.

AD-05

3. Inspection

- a. Rim for complete welds

AK

4. Frame assembly – Lid

- a. General
 - i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing)
- b. Insert rim from step 2 into jig.
- c. Cut and fit $\frac{3}{4}$ " x 0.035 material, 21" long, for lid cross members.
- d. Record material PO on attached material list.
- e. Remove writing on tubes with acetone and scotch bright.
- f. Drill vent holes into rim to vent cross members into rim.
- g. Locate cross members in lid rim. Refer to drawing for spacing of cross members. Clamp cross members with C-clamps to jig.

AD06 x10

5. Frame assembly – Lid with optional walkway modification

- a. Fit cross members to rim in accordance with step 4.
- b. Attach walkway jig with C-clamps. Ensure correct orientation of rim, refer to drawing.
- c. Cut $\frac{1}{2}$ " x 0.035 material for walkway stringers to fit between lid cross members. Record material PO on attached material list.
- d. Drill vent holes into cross members at walkway stringers.
- e. Align walkway stringers on walkway jig using cleco clamps near both ends of each stringer, and clamp stringer to jig using a C-clamp in the centre.

AD06 x10

6. Weld frame assembly.

- a. Record welding rod PO on attached material list.
- b. Jigs must remain in place for as long as practical during welding.

AD-05

7. Inspection

- a. Frame assembly for complete welds.

AD06 x10

CARGO BASKET LID FABRICATION

Complete
(initial or SCA #)

ADP xrb

8. Mesh assembly.

Note: 95912 (Bell 429) does not have mesh. Skip to step 10.

- a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- b. Cut mesh to size for lid.
- c. Remove surface rust with scotch-brite.
- d. Ensure lid is prepared for mesh on the correct side.

9. Weld mesh to frame assembly per drawing.

AD-OS

- a. General welding requirements for all lids:
 - i. Every intersection on all edges.
 - ii. First 5 intersections along cross members, then every second intersection.
- b. MIG weld both short sides.
- c. Clamp lid over spacer at centre of lid to pre-tension mesh.
 - i. $\frac{3}{4}$ " for lids under 76"
 - ii. 1" (check) for lids over 76"
- d. Weld remainder of mesh as indicated in a.
- e. Record welding rod PO on attached material list.

10. Weld lid components.

AD-OS

- a. Handle brackets, locate in accordance with drawing.
 - i. Standard location: $\frac{1}{4}$ " outside of last cross member on both ends.
 - ii. Record handle bracket WO and welding rod PO on attached material list.
- b. Lid prop bushing(s).
 - i. one or two in accordance with drawing.
 - ii. Record lip prop bushing WO and welding rod PO on attached material list.
- c. Placard bracket. – not installed on 95912 (Bell 429)
 - i. Locate on cross member to set bracket in centre bay of lid.
 - ii. Record placard bracket WO and welding rod PO on attached material list.

11. Clean up

ADP 65

- a. Grind high spots off mesh welds.
- b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out.
- c. Straighten lid using frame attached under welding table. Work carefully, avoid excessive force to prevent kinking rim tubes.
- d. Drill #9 through lid prop bushing(s). De-burr hole(s).
- e. Drill for lid bumpers using $\frac{1}{4}$ " (#3) centre drill.
 - i. 3 places for lids under 76"
 - ii. 4 places for lids over 76"
- f. Remove surface rust with scotch-brite pad.

12. Final Inspection

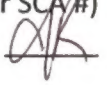
To be completed by a different person than the previous steps.

OR

- a. Basket lid assembly for complete welds, and required minimum mesh weld locations.
- b. Material lists complete.
- c. Overall condition and conformity to drawing(s).

CARGO BASKET LID FABRICATION

Complete
(initial or SCA #)



13. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag lid assembly and place into stock in preparation for assembly.

Work Order:

2015-81

Date Opened:

15-Jul-15

Material Tracking Sheet

Bell 206L / 407 and Eurocopter AS350 / AS355

Standard Lid Fabrication

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
			69812-01	Lid Assembly		
Step 1				Rim Assembly		
	. 2		--	3/4" Tube - Long Rim (75.75")	4130 Steel, 3/4" x 0.035 Sqr. Tube	14009
	. 2		--	3/4" Tube - Short Rim (22.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	14009
Step 2				Weld Rim Assembly		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	14033
Step 3				Inspection - Rim	None	
Step 4				Frame Assembly		
	. 3		--	3/4" Tube - Cross Member (21")	4130 Steel, 3/4" x 0.035 Sqr. Tube	14005
Step 5		70405		Option: Frame Assembly - with walkway		
	. 8		--	1/2" Tube - walkway	4130 Steel, 1/2" x 0.035 Sqr. Tube	14009
Step 6				Weld Frame Assembly		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	14033
Step 7				Inspection - Frame Assembly	None	
Step 8				Mesh Assembly		
	. 1		--	Mesh (lid - 75" x 22")	3/4-16F Expanded Mild Steel sheet	15037 / 12065
Step 9				Weld Mesh		
	. A/R		--	Welding Rod	ER70S-6 MIG Wire	15027

Work Order: _____

Date Opened: _____

Material Tracking Sheet
Bell 206L / 407 and Eurocopter AS350 / AS355
Standard Lid Fabrication

2 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 10				<i>Weld Lid Components</i>		
Step 10.a.	. 1	84262	84262-01	Upper Handle Bracket Assembly		
	. . 4		36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	} 2014-36
	. . 2		36275-02	Support	304 Stainless, 5/16" Rod	
	. A/R		--	Welding Rod	ER308L TIG Rod	
Step 10.b.	. 2		49216-01	Spacer (Lid prop)	304 Stainless, 1/2" Dia.	2015-07
	. A/R		--	Welding Rod	ER308L TIG Rod	14005
Step 10.c.	. 1		36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	2014-81
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	14033
Step 11				<i>Clean Up</i>		
Step 12				<i>Inspection - Final Assembly</i>		
Step 13				<i>Powder Coating</i>		



Description: _____

WO# 215-8

See build sheets